

Date: Monday, 16/10/2006 7:47:54 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET, GAS SPRING
Job Number	: 28949		
Estimate Number	: 10179		
P.O. Number	: <i>N/A</i>	Part Number	: D2144
This Issue	: 16/10/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2144 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/10/2006 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 28976	Material	: <i>N/A</i>
Written By	:	Due Date	: 19/10/2006
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est: 04.05.06 Reformat KJ/RF Est Rev:E Now on Waterjet 06-10-15 JLM		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
Comment: Qty.: 0.0945 sf(s)/Unit Total : 3.7800 sf(s) 304/316 .063 Sheet 16GA Batch: <i>M101463</i> <i>mm 06/10/17</i>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D2144 Dwg Rev: <i>D</i> <i>mm 06/10/17</i> <i>(42)</i> Prog Rev: <i>D</i> 2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>mm 06/10/17</i> <i>(42)</i>			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <i>Joe 10.20</i> <i>(42)</i> <i>counted</i>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <i>mmf.</i> <i>06/10/24</i> <i>(42)</i>			

Process Sheet

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Part Number: D2144

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 06/10/24

(42)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10.24 (42)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004
2- Grind flush

PD 06-10-24

(42)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/10/25 42

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10.25

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

an 06/10/26 x 42

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

VB 06/10/26

(42)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 51218

PD 06/10/26

(42)

c 206/10/27

Date: Monday, 16/10/2006 7:47:55 AM
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Process Sheet

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Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 28949

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(42)

Comment: FINAL INSPECTION/W/O RELEASE

1706/10/27

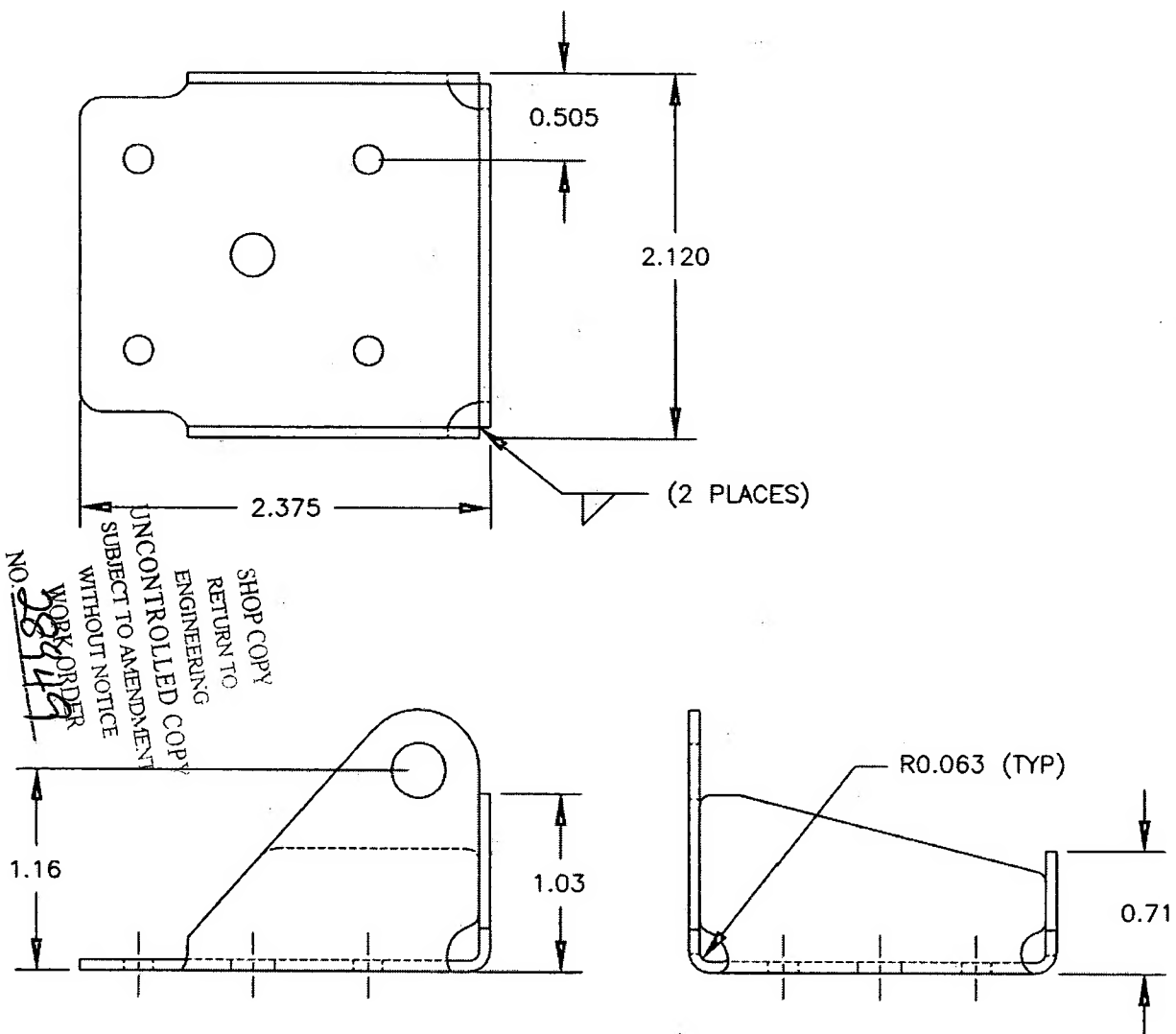
Job Completion





RELEASED
98.10.15 AE D

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
BW	AE		
CHECKED MA	APPROVED AE	DRAWING NO. D2144	SHEET 1 OF 2
DATE 98.10.08	TITLE HINGE BRACKET	SCALE 1:1	
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	



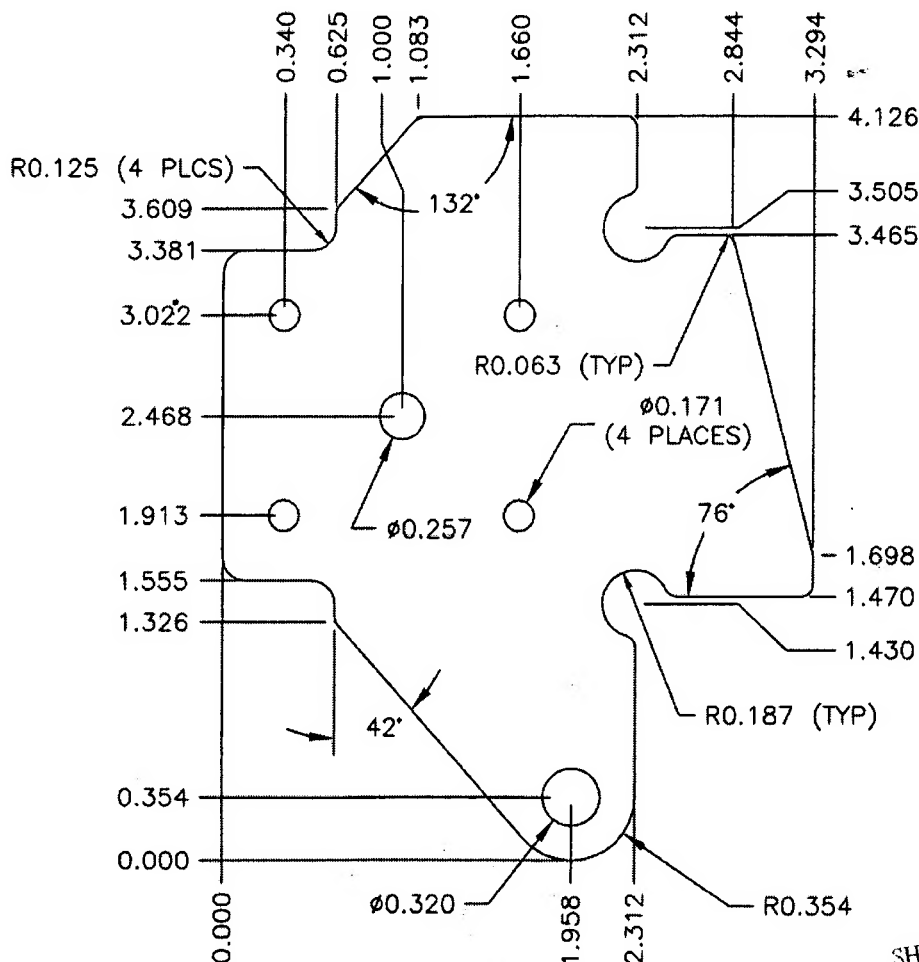
FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28949



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 LB



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 28949

DART AEROSPACE LTD		Work Order: 28949
Description: Hinge bracket, Gas Spring		Part Number: D2144
Inspection Dwg: 2144 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.171	+0.005-0.001	0.171	✓		VERN	
Ø 0.257	+0.006-0.001	0.257	✓		VERN	
Ø 0.320	+0.006-0.001	0.320	✓		VERN	
4.126	+/- 0.010	4.128	✓		VERN	
3.294	+/- 0.010	3.300	✓		VERN	
0.340	+/- 0.010	0.342	✓		VERN	
1.000	+/- 0.010	1.002	✓		VERN	
1.660	+/- 0.010	1.662	✓		VERN	
1.958	+/- 0.010	1.959	✓		VERN	
2.312	+/- 0.010	2.312	✓		VERN	

Measured by: <i>MM</i>
Date: 06/10/17

Audited by: <i>[Signature]</i>
Date: 06/10/20

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	